

shp 30-31/10 1

Date: Thursday, 25/10/2007 2:35:02 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STEP WELDMENT
Job Number : 35402	
Estimate Number : 12577	
P.O. Number :	Part Number : D3562042
This Issue : 25/10/2007 S.O. No. :	Drawing Number : D3562 UNDER REVIEW
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : C
Previous Run : 35263	Material :
Written By :	Due Date : 01/11/2007 Qty: 1 Um: Each
Checked & Approved By :	
Comment : Est Rev:A New Issue 06-11-09 JLM Est rev B ECN 987 07.10.09 EC verified by: DD	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2622120C	Extrusion
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Qty	Part #	Description	Batch:
1	D2622-120C	Extrusion	<u>34694</u>

Check Material for any Dents or Defects

PE 07-10-25 1

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622 extrusion as per Dwg D3562

2-Deburr and bevel ends for welding

PE 07-10-25 1

PE 07-10-25 1

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

5 07/10/26

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

PE 07-10-26 1

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

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Drawing Name: STEP WELDMENT

Job Number: 35402

Part Number: D3562042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

5.0 2/10/29

6.0

D3560042

ARM WELDMENT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

ARM WELDMENT

B 34475

11-07-10-27

7.0

D3560044

ARM WELDMENT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

ARM WELDMENT

Batch:

B 34477

11-07-10-27

8.0

MS20600AD4W5

Blind Rivet



Comment: Qty.: 36.0000 Each(s)/Unit Total : 36.0000 Each(s)

Blind Rivet

batch:

M105125

11-07-10-27

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Transfer drill Rivet holes as per dwg D3562.

2-Touch-up rivet holes with alodine as per dwg d3562

3-Rivet legs using Magnabond as per dwg D3562.

*****Ensure to wipe off any excess magnobond *****

B104677

11-07-10-27

11-07-10-27

11-07-10-27

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5.0 2/10/29

11.0

D2734

206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D2734

End Cap

B 34485

11-07-10-29

W/O:		WORK ORDER CHANGES					
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Process Sheet

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Drawing Name: STEP WELDMENT

Job Number: 35402

Part Number: D3562042

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld end caps as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024.

A/R Aluminum Rod M105058

2-Grind end cap welds flush as per Dwg D3562

07.10.29 1

07.10.29 1

13.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07-10-29 ①

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/10/30 ①

15.0

POWDER COATING

POWDER COATING

(+) TOUCH-UP ROD IN END CAPS

07-10-30 ①



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M-105 914

BR 07-10-30

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3562 and QSI 005 4.4

Batch: M106030

M-f 07/10/30

1K

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

mf 07-10-30 ①

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Assembly Kit

07/10/31 ①

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
07-10-30	17A	Install bushing D2808 #B <u>32896</u>	MF	07-10-30	2			
07/10/30	17B	Zusped level ec #5	S	07/10/30	(11)			

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QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

QC21

FINAL INSPECTION/W/O RELEASE



07.10.31 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



6 07.10.31

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W/O:		WORK ORDER CHANGES					
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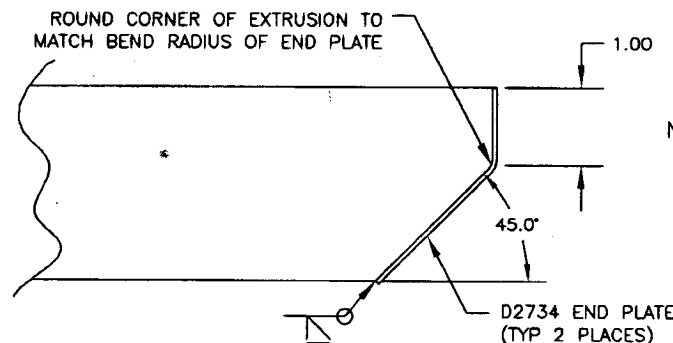
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DART

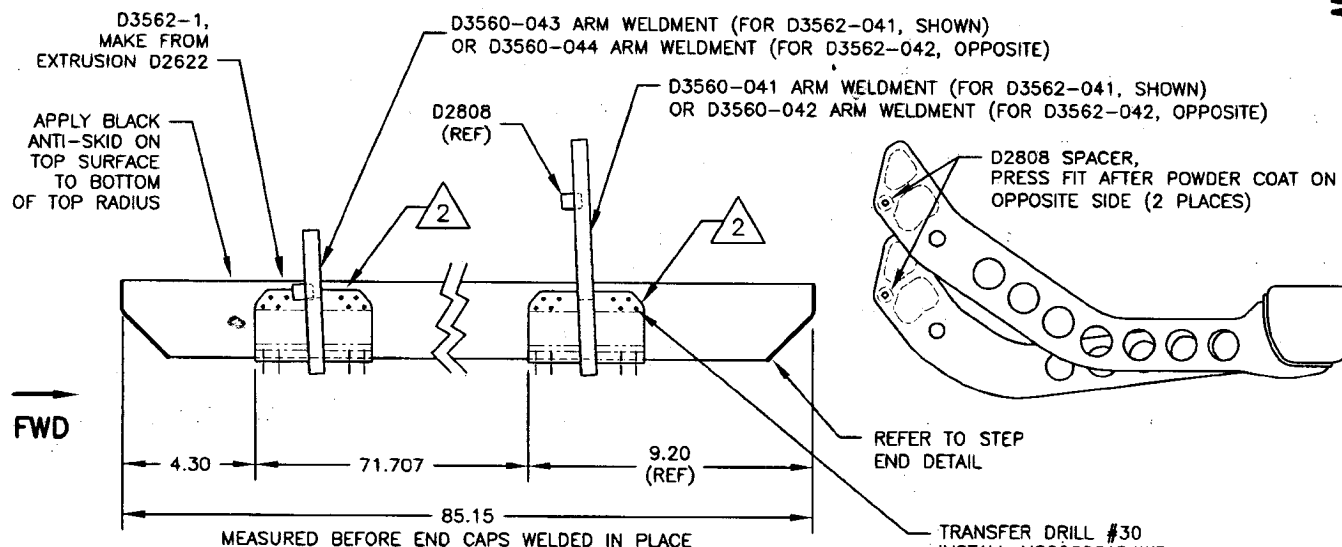
RELEASED
07.06.29
07.10.22 DC

UNDER REVIEW



TYPICAL STEP END DETAIL
NOT TO SCALE

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004



D3562-041 LH STEP ASSEMBLY (SHOWN)
D3562-042 RH STEP ASSEMBLY (OPPOSITE)

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) INSTALL ARM WELDMENTS WITH A LAYER OF MAGNOBOND 6398 BETWEEN THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH MAGNOBOND 6398. CLEAN OFF EXCESS BEFORE POWDER COATING.
- 3) WELD PER DART QSI 004
- 4) FINISH:
 - i) CHEMICAL CONVERSION COAT STEP EXTRUSION PER DART QSI 005 4.1 BEFORE ASSEMBLY
 - ii) POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3. TOUCH UP ANY UNFINISHED MAGNOBOND WITH PAINT PER DART QSI 005 4.2
 - iii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 5) ALL DIMENSIONS ARE IN INCHES

DESIGN	DRAWN BY	DART AEROSPACE LTD
07.06.29	07.10.22 DC	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	REV. C
DATE	TITLE	SHEET 1 OF 1
07.06.19	STEP ASSEMBLY	SCALE NTS
A	06.09.26	NEW ISSUE
B	07.01.15	ARMS NOW RIVETED TO STEP
C	07.06.19	NOW MAGND, ADD D2808, RMV 4 RVTS

4035402

Dart Aerospace Ltd

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